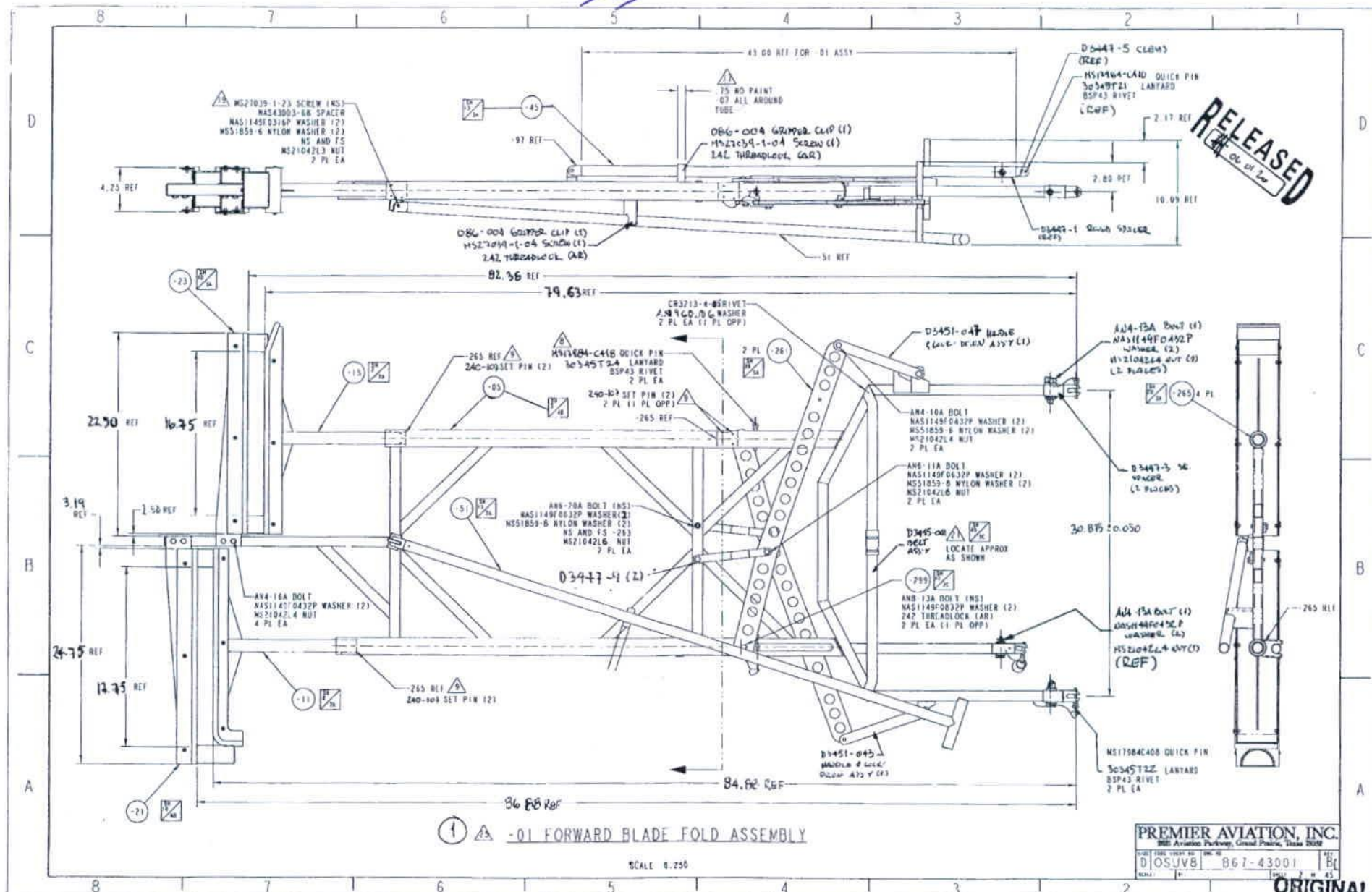


REFERENCE ONLY

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REFERENCE ONLY

RELEASED
JUL 24 1964



REV STATUS OF SHEETS	REV SHEET	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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REVISIONS			
REV	DESCRIPTION	DATE	APPROVE
1	MFG. RELEASE	10/12/95	WJ
A	CHANGES TO IMPROVE FUNCTIONALITY	3/7/96	WJ
B	DWG AND P/L REVISED AND UPDATED TO REFLECT BELI MODIFICATIONS	8/15/96	WJ
B1	CHANGED DOWEL AFTER FIRE	4/5/98	


INSTRUCTION: TYPED IN OR BY 042 695-1)

1. IDENTIFY PART PER PRIMER IDENTIFICATION AND MARKING PROCEDURES 15-1712. LOCATION, CHARACTER HEIGHT, AND PROCESS AS REQUIRED. MARK IN CONTRASTING COLOR.
2. FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03. (EXCEPT AS NOTED FOR MACHINED PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX. (EXCEPT AS NOTED).
3. GENERAL SHOP PRACTICES I.A.W. PRIMER SPEC. DDB-93000 AND AC43.13.
4. OPEN
5. WELD PARTS PER MIL-2219, CLASS B.
6. CHEN FILM (ALODINE) ALL ALUMINUM DETAIL PARTS PER PRIMER SPEC DDB-93003, CLASS 1A, AND PRIME WITH [POXY PRIMER PER MIL-P-23377C, ZINC CHROMATE PRIMER PER MIL-ITP-1757, OR EQUIVALENT.
7. STITCHING PER FED-STD-751.

26. TOLERANCE ON DECIMAL .X.X.X
27. LAST SECTION LETTER USED "A"


- WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS MOST EXTENDED POSITION (7-HANDLE LOCKED ON LOWEST HOOKS), DRILL A .25 DIA HOLE THROUGH THE OUTER TUBE .35 BELOW THE BOTTOM OF THE INNER TUBE AND INWARD FROM THE OUTER SIDE OF THE OUTER TUBE. UNLOCK THE INNER TUBE CRADLE ASSEMBLY AND MOVE IT TO ITS LOWEST, MOST RESESED POSITION. MATCH DRILL THE INNER TUBE TO THE HOLE JUST DRILLED IN THE OUTER TUBE. .25 DIA.

- 7d. INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE.
MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE
USING 1/8" DIAMETER DRILL. INSERT 803073 SET P.I.N.
AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL (A BUSHING))

-  **ALIGN CRADLE ASSEMBLY**
90 DEGREES FROM THE CENTERLINE AXIS OF THE
BURNING ON THE OTHER END OF THE TUBE.
WELD GUSSET ON CENTER WITH TUBE AND BOTTOM
OF CRADLE ASSEMBLY.

- 
- CHAMFER EDGE FOR BETTER WELDING.

- 13 TAP HOLE TO 1/4-20 THRU

-  INSTALL CL-40-SBP-3 DETENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAT SURFACE. ALIGN THE TUBE IN THE FIXTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER SLOWING.

15. PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN880 WASHER FOR NAS1149 WASHER UNTIL CURRENT STOCK IS DEPLETED.

16. PAINT ALL ASSEMBLIES AND WELMENTS AS REQUIRED,
EXCEPT WHERE NOTED, 23663U W OHS A YELLOW, PER FED-STD-525.

- NO PAINT REQUIRED, CHEM FILM ONLY WHERE APPLICABLE.
PER PREMIER SPEC 008-93003.

- 16 STITCH APPROX AS SHOWN, PER FED-STD-751.

- PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER WSS1859 EQUIVALENT.

- DISENGAGE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BLADEFOLD ASSY TO AIRCRAFT

RELEASED
06-01-20

ECO
5007
5161
6262

REFERENCE ONLY

SEE SEPARATE PARTS LIST B67-43001PL

PRECEDENCE:	PROJECT SCHEDULE: DATE OF DEL. 01/12/2015	SHIPPED BY: R. W. H.	DATE: 01/12/2015	PREMIER AVIATION, INC. 9000 Aviation Parkway, Grand Prairie, Texas 75008
	DECIMALS: 11. 8.03	ANGLES: 11/12	WEIGHT BY: 11/12/2015	
11/12/2015	SHIP: 01/12/2015	APPROVED BY: RALF HANNAKER	DATE: 01/12/2015	BLADE FOLD KIT
	RECEIVED: 01/12/2015	RECEIVED BY: 01/12/2015		
	ACTIVE PROJECT BY: PRO/ENGINEER	DATE: 01/12/2015	DATE: 01/12/2015	

ORIGINAL

Date: Tuesday, 23/09/2008 9:51:53 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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41.0	30345T24	LANYARDS
------	----------	----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
LANYARDS
batch: m108973

mf 08-10-24

42.0	240107	SPRING SLOTTED PIN
------	--------	--------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
SPRING SLOTTED PIN
batch: m17850

mf 08-10-24

43.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1 SAD
1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.
242 THREADLOCK batch: m109687

M-1/F2
08-10-30

44.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/30 (x2)

45.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

PM 41184 41183

08/10/30 (2)

46.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

08/10/30

Job Completion



mf 08-10-30

Date: Tuesday, 23/09/2008 9:51:53 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: m104547

mf 08-10-24

35.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: m18180

mf 08-10-24

36.0

BSP43

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

RIVET

batch: m109119 x10, m10911 m17890 x6

mf 08-10-24

37.0

CR3213405

cherry rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

cherry rivet

batch: m104214

mf 08-10-24

38.0

MS17984C408

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIN, QUICK RELEASE

batch: m108986

mf 08-10-24

39.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

PIN, QUICK RELEASE

batch: m108991 x4, m108986 x4

mf 08-10-24

40.0

30345T22

8" LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

8" LANYARD

batch: m108390

mf 08-10-24

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: 108057

mf 08-10-24

28.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: 18057

mf 08-10-24

29.0

AN960JD6

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch: 4085

mf 08-10-24

30.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: m103962 x 4 m101291 x 4

mf 08-10-24

31.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch: m107959

mf 08-10-24

32.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch: 19278

mf 08-10-24

33.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch: m105558

mf 08-10-24

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

batch: M107499

mf 08-10-24

21.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

batch: M105077

mf 08-10-24

22.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: M108473

mf 08-10-24

23.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

WASHER

batch: M108986

mf 08-10-24

24.0

NAS43DD368

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

SPACER

batch: M108473 X 8

mf 08-10-24

25.0

NAS1149F0316P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

WASHER

batch: M103473

mf 08-10-24

26.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s)

Washer

batch: ~~108~~ 18057

mf 08-10-24

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D34473

Square Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Square Spacer

batch: B 24416 x 6, B 41351 x 2

mf 08-10-24

14.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Swing Arm

batch: B 41278 x 8

mf 08-10-24

15.0

D3445041

Belt Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Belt Assembly

batch: B 39966 x 2

mf 08-10-24

16.0

086004

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inventory

batch: m17850 x 8

mf 08-10-24

17.0

MS27039104

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inventory

batch: B 18431

mf 08-10-24

18.0

MS27039123

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

SCREW

batch: 18057

mf 08-10-24

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: 108701

mf 08-10-24

Date: Tuesday, 23/09/2008 9:51:52 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD BLADE FOLD ASSEMBLY

Job Number: 41290

Part Number: PB674300101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB674300145

Longitudinal Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Longitudinal Support Assembly
batch: 41013

MF 08-10-21

7.0

PB674300151

Long T-Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Long T-Handle Assembly
batch: 41581

MF 08-10-21

8.0

PB6743001261

Lever Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Lever Arm
batch: 41411 x 2 41294 x 1

MF 08-10-21

9.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
Bushing
batch: B40056 B.41373

MF 08-09-23

10.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Bushing
batch: B40062

MF 08-09-23

11.0

D3451048

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Handle and Lock-Down Assembly
batch: B41064 x 2 B41076 x 2

MF 08-10-24

12.0

D3451047

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Handle and Lock-Down Assembly
batch: B41034 x 2 B41279

MF 08-10-24

Date: Tuesday, 23/09/2008 9:51:52 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSEMBLY
Job Number	: 41290 <i>2</i>		
Estimate Number	: 13531		
P.O. Number	:	Part Number	: PB674300101
This Issue	: 23/09/2008 S.O. No. :	Drawing Number	: B6743001 P.1, 2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 18/08/2008 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41237	Material	:
Written By	:	Due Date	: 15/09/2008
Checked & Approved By	: <i>mf 08-09-23</i>	Qty:	<i>split 2</i> <i>4</i> Um: Each
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300107	Fwd Blade Fold Assembly Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

X Fwd Blade Fold Assembly Weldment

batch: *42753*

mf 08-10-30

2.0	PB674300115	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: *640608 X 2 41367*

mf 08-10-24

3.0	PB674300111	Fwf Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Fwf Adjustable Blade Support Assembly

batch: *41365*

mf 08-10-24

4.0	PB674300121	PB67-43001-21
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-21

batch: *41370*

mf 08-10-24

5.0	PB674300123	PB67-43001-23
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

PB67-43001-23

batch: *41371*

mf 08-10-24